

a radiation-cured varnish over the printed image, the radiation-cured varnish formed by:

coating the printed image with a radiation-curable varnish comprising one or more polymerizable reactants and optionally one or more photoinitiators, wherein the radiation-curable varnish includes less than about 20 % monofunctional monomer based on the weight of the radiation-curable varnish; and

B1 subsequently exposing the radiation-curable varnish to radiation sufficient to polymerize at least 90 weight % of the one or more polymerizable reactants;

wherein when the coated, printed film is tested according to the FDA migration test protocol, no more than 50 parts per billion total of any of the polymerizable reactants and the optional photoinitiators migrate within 10 days at 40°C from the coated, printed film into a food simulant selected from the group consisting of i) 95 weight % ethanol and 5 weight % water and ii) 5 weight % ethanol and 95 weight % water, the food simulant enclosed within a test container formed from the coated, printed film so that the food simulant contacts the food side of the substrate film and the ratio of volume of food simulant to surface area of coated, printed film is 10 milliliters per square inch.

B2 6. (Amended) The packaged food of claim 1 wherein the substrate film comprises polyvinyl alcohol.

B3 22. (Amended) A packaged food product comprising:

a food product;

a package enclosing the food product, the package comprising a coated, printed film comprising:

a substrate film comprising one or more thermoplastic materials, the substrate film having a print side, an opposing food side, and an average thickness of less than about 15 mils;

an image printed on the print side of the substrate film;

a radiation-cured varnish over the printed image, the radiation-cured varnish formed by:

coating the printed image with a radiation-curable varnish comprising one or more polymerizable reactants; and

subsequently exposing the radiation-curable varnish to an electron-beam radiation source having an energy of less than 100 keV in an amount sufficient to polymerize at least 90 weight % of the polymerizable reactants.

Please add new claims 27-40 as follows:

27. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 10 % monofunctional monomer based on the weight of the radiation-curable varnish.
28. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 5 % monofunctional monomer based on the weight of the radiation-curable varnish
29. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 1 % monofunctional monomer based on the weight of the radiation-curable varnish
30. (New) The packaged food of claim 1 wherein the radiation-curable varnish is essentially free of monofunctional monomer.
31. (New) The packaged food of claim 1 wherein the radiation-curable varnish is essentially free of reactive diluent.
32. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 20 % monofunctional oligomer based on the weight of the radiation-curable varnish.

33. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 10 % monofunctional oligomer based on the weight of the radiation-curable varnish.

34. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 5 % monofunctional oligomer based on the weight of the radiation-curable varnish.

35. (New) The packaged food of claim 1 wherein the radiation-curable varnish includes less than about 1 % monofunctional oligomer based on the weight of the radiation-curable varnish.

36. (New) The packaged food of claim 1 wherein the radiation-curable varnish is essentially free of monofunctional oligomer.

37. (New) The packaged food of claim 1 wherein the substrate film comprises highly crystalline polyamide.

38. (New) The packaged food of claim 1 wherein the substrate film comprises one or more of the polymers selected from the group consisting of acrylonitrile-butadiene copolymer, isobutylene-isoprene copolymer, and polyacrylonitrile.

39. (New) The packaged food of claim 1 wherein the substrate film comprises one or more of the polymers selected from the group consisting of highly crystalline polypropylene and highly crystalline polyethylene.

40. (New) The packaged food of claim 1 wherein the substrate film comprises polyvinylidene chloride.

Support for the amended and new claims may be found in the application as originally filed, for example as follows:

Claims 27-30 – page 24, lines 18-20;

Claim 31 – page 35, lines 8-10; and

Claims 32-36 – page 24, lines 20-24.